

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026681**Date Inspected:** 09-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of the shift this Quality Assurance Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QAI Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

William Clifford-OBG E12/E13 (Longitudinal Stiffener) OBG W13/W14 ("D1" Bottom Plate and "H" Bottom Side Plate) and Ultrasonic Testing.

Douglas Frey-Lifting Lug Holes at OBG W11 and W14

Craig Hager-OBG W14 Lifting Lug and Ventilation Holes.

Art Peterson-Punch List Items

Joselito Lizardo-OBG E13/E14 ("D1" Bottom Plate, "H" Bottom Side Plate) and OBG E12/E13 (Longitudinal Stiffener) and Magnetic Particle Testing.

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Craig Hager, Art Peterson, Joselito Lizardo, Douglas Frey and William Clifford monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and no issues were noted on this date.

This QALI was informed by the QA inspector, Joselito Lizardo, about the loss of preheat of the "A" deck longitudinal stiffener identified as 12E-13E-A-LS4. Per this QALI instructions Mr. Lizardo generated an Incident Report (TL-015) in regards to this issue on this date. This QALI also contacted QA Supervisor, William Levell, to advise him of this issue. See Summary of Conversations for additional information.

For additional detailed information see the individual, submitted and approved, QA Weld Inspection Reports (WIR).

This QA Inspector continued the daily review of field inspection reports and update of the field document control tracking records regarding the Orthotropic Box Girders (OBG, Longitudinal and Transverse "A" Deck Stiffeners, Deck Access Holes and the Tower Shear plates).

Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

In regards to the loss of preheat issue of the longitudinal "A" deck longitudinal stiffener identified as 12E-13E-A-LS4, this QALI informed the QC Lead Inspector, Bonifacio Daquinag, Jr., that QA would generate an Incident Report TL-015. Later in the shift, Mr. Daquinag informed this QALI that a Non-Conformance Report would generated by ABF Quality Control Department.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
